

**Work Order ID 59815**

Friday, June 11, 2010 10:47:30 AM



Page 1

Item ID: D3975-1

Accept



Setup

Start



Revision ID:

Item Name: Gas Cylinder

Stop



Start Date: 6/11/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10/6/11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3975

B

100



Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O:

12073

Possible Supplier: Clippard Instrument Laboratory

Part Number: Heavy Duty Brass Cylinder 7DIH

Material release note is required

CY 10/6/11

(10)

110



Packaging

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

Memo

0.00

Ensure material certification is attached

PC 10/8/29

(10)

120



QC

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Quality Control

S w b o u l 30

(H10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59815**

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Page 2

Item ID: D3975-1

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Memo	0.00							
Small Fab	Identify with vibrating stylus as per dwg D3975	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150  Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify as per dwg and Stock Location: _____								

6/10/07/05 (10)

6/10/07/05

(10)

6/11/05 (a)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

**Work Order ID 59815**

Friday, June 11, 2010 10:47:30 AM



Page 3

Item ID: D3975-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Gas Cylinder

Start Date: 6/11/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*100706**MF  
10-7-5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 11, 2010 10:47:43 AM

Page 1

Work Order ID: 59815

Parent Item: D3975-1

Parent Item Name: Gas Cylinder

Comments: IPP Rev:A 10.05.27 as per ECN10-548 DD verf:EC

Start Date: 6/11/2010

Required Date: 6/18/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

7D-1-H

Purchased

No

110

Each

0.0000

1

10



Clippard Brass Cylinder



*PC 14/6/29 (10)*

D 3974-1

B 52629

*(10K)*

*ES 10/07/05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

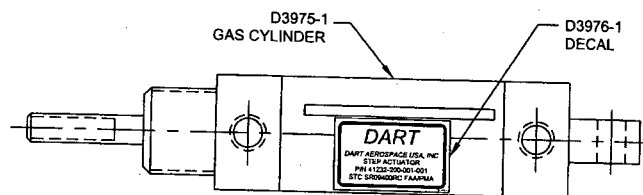
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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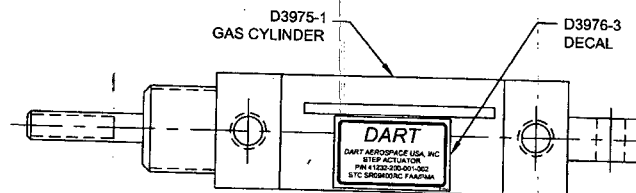
**NOTE:** Date & initial all entries



ITEM No.	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
1	X		D3975-041	GAS CYLINDER ASSEMBLY (LH)
2		X	D3975-042	GAS CYLINDER ASSEMBLY (RH)
3	1	1	D3975-1	GAS CYLINDER
4	1		D3976-1	DECAL
5		1	D3976-3	DECAL



**D3975-041 GAS CYLINDER ASSEMBLY**



**D3975-042 GAS CYLINDER ASSEMBLY**

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 59875  
BS-0-6-4

RELEASED  
 2010-05-20

B	CORRECTED TYPO: D3976-3 WAS D3975-3 (ZN D7-1).	MB	10.04.13
A	NEW ISSUE	AJS	09.07.09
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	J	DRAWING NO.	REV. B
CHECKED	J	D3975	SHEET 1 OF 2
MFG. APPR.	J	TITLE	SCALE
APPROVED	J	GAS CYLINDER ASSEMBLY	NTS
DE APPR.	J	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	10.04.13		

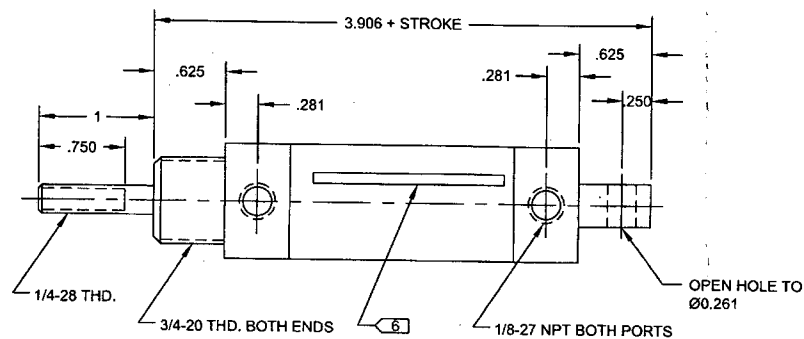
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D3975-1 BRASS CYLINDER**

**NOTES:**

- 1) MATERIAL: CROSS REFERENCE Era DRAWING 41232-200-007  
PURCHASE P/N: HEAVY DUTY BRASS CYLINDER 7D1H  
VENDOR: CLIPPARD INSTRUMENT LABORATORY, INC, CINCINNATI, OH.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH Era P/N 41232-200-007-001 USING VIBRATING STYLUS
- 7) WEIGHT: 0.74 lbs APPROX
- 2) BORE: 0.875 INCHES
- 3) ROD: ROTATING.
- 4) 7D1H CONFIGURED WITH HYD. FLUID SEALS.
- 5) TEMPERATURE RANGE: 30° F TO 230° F.
- 6) MOUNT: UNIVERSAL MOUNT.
- 7) ACTION: DOUBLE ACTING.
- 8) STROKE: 1.000 INCH.
- 9) POWER FACTOR: 0.6 SQ. IN.
- 10) PORTS: 1/8 NPT.
- 11) ROD DIAMETER: 0.25 INCHES.
- 12) SINTERED BRONZE ROD BUSHING.
- 13) PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

*WLO 59815*

**RELEASED**  
2010-05-20

DESIGN	435	<b>DART AEROSPACE USA, INC</b>	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	P	DRAWING NO.	REV. B
MFG. APPR.	SS	D3975.	SHEET 2 OF 2
APPROVED	42	TITLE	SCALE
DE APPR.	H	GAS CYLINDER ASSEMBLY	NTS
DATE	10.04.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC	
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**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO12073

Purchase Order Date 6/11/10

PO Print Date 6/14/10

Page Number 1 of 1

Order From :

VC-ROY001

RBC ROYAL BANK - VISA  
PAYMENT CENTRE, PO BOX 4016, STAT. A  
TORONTO, ON M5W 1X6  
CA

REORDER

Contact Name  
Vendor Phone  
Vendor Fax  
Vendor Account Nbr

Buyer Chantal Lavoie  
Requisition Nbr  
Tax Resale Nbr 10127-2607  
Terms COD  
Currency CAD  
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

FAKED  
6/10/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	7D-1-H	Clippard Brass Cylinder	6/29/10 Yes	10.00 Each	FedEx PI ppd	\$100.9700	\$1,009.70

Special Inst: AS PER DWG D3975 REV. B  
B59815  
WAINBEE P/N: 7D-1-H□

PO Total: \$1,009.70

CERTIFICATE OF CONFORMITY  
REQD UPON DELIVERY

PO Instructions: WAINBEE LTEE  
VISA:4516 0500 0053 0448 EXP DATE:05/14

Change Nbr: 3

Change Date: 6/14/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



WAINBEE LIMITED  
215 BOUL BRUNSWICK  
POINTE CLAIRE, QC H9R 4R7  
Phone: 514-697-8810 Fax: 514-697-3070

# Packing List

PO12073

RELEASE # 11223848-1

DATE 06/28/10 14:12:03

127404  
DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7  
613-632-3336

## SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7

ORDER NUMBER 11223848	ORDER DATE 06/14/10	SHIP DATE 06/28/10	WRITTEN BY Frederic Lavoie	CONTACT CHANTAL LAVOIE		
CUSTOMER P/O NUMBER PO12073						
JOB #						
RELEASE # E						
PRODUCT / DESCRIPTION		QUANTITY OPEN	U/M	QUANTITY SHIPPED	QUANTITY BACKORDERED	PRICE / EXTENSION
7D-1-H  CLIPPARD BRASS CYLINDER		10	EA	10	0	100.970
						1009.70

*8/10/06/10*

Wainbee's Standard Terms and Conditions Apply  
Returned Goods Not Accepted Without Prior Authorization.  
Claims For Shortages Or Losses Are Not Accepted 10 Days After Shipment.

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